

Work Order ID 71715

Thursday, July 07, 2011 1:00:32 PM



Page 1

Item ID:	D3212-1	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Floor Window					
Start Date:	7/7/2011	Start Qty: 6.00		Cust Item ID:		
Required Date:	7/21/2011	Req'd Qty: 6.00		Customer:		
Reference:						

Approvals:	Process Plan:	<u>CZ</u>	Date:	<u>11/07/07</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3212	Rev B

100		0.00							
	FLOW WATER JET								
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut blankas per Dwg D3212 <input type="checkbox"/> Dwg Rev: <u>B</u> <input type="checkbox"/> Prog Rev: <u>B</u>								
	<input type="checkbox"/> 2-Deburr if necessary								

BH-8-16

(10)

110		0.00							
	HAAS CNC VERTICAL MACHINING #1								
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	Machine as per Folio FA349 and Dwg D3212								

an 11/08/12

~~BH-8-16~~ 10

120		0.00							
	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									

an 11/08/18

10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 71715

Thursday, July 07, 2011 1:00:32 PM



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Item ID: D3212-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Floor Window

Start Date: 7/7/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 7/21/2011 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00

SL 11-08-18



QC

Memo

0.00

Quality Control

140

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

1-Deburr if necessary 2-Install label as per Dwg D3212 3-polish abrasion scratches if necessary.. 4-Wrap in plastic wrap after inspection

EP 11/08/22 (10)
Pto

150

QC5- Inspect part completeness to step on W/O

0.00

S wlos/23



QC

Memo



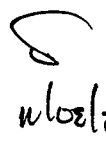
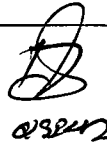

0.00

Quality Control

(48) (42)

W/O: 71715		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D322-1 PAR #: N/A Fault Category: Small Fad NCR: Yes No DQA: AS Date: 11/08/23
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: AS Date: 11/8/25

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11/08/22	#140	employee scribbles the wrong Part #. P.C. LQA. got the numbers mixed up.		-unable to save window Scrap + Destroy qty 2 no real fix	 11/08/23	 11/08/23	 11/08/23	 11/08/22
		(w/o + Drawn are clean)						

NOTE: Date & initial all entries

Work Order ID 71715



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Thursday, July 07, 2011 1:00:32 PM

Item ID: D3212-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Floor Window

Start Date: 7/7/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 7/21/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

Identify as per dwg & Stock Location:

ST 210

0.00



Packaging

Memo

0.00

Packaging

S

SP 11-08-24

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/8/24

11-08-24
10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, July 07, 2011 1:00:30 PM

Page 1

Work Order ID: 71715

Parent Item: D3212-1

Parent Item Name: Floor Window





Start Date: 7/7/2011

Required Date: 7/21/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev: A New Issue 05-11-09 JLM
 IPP Rev: B Water jet/ ccn798 06-05-08 EC
 IPP rev.C back on haas 07.04.09 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2728-1  Dart Logo label		Manufactured	No			100	Each	0.0000	0	0			
MACRLICS.125  1/8" Polycast II Sheet		Purchased	No			140	sf	251.4934	0.9745	6.154737	10		

Location

Loc Qty

Loc Code

MAT

142.2467

117431

142.2467

MAT018

106.2467

117324

43.7667

117340

62.48

MAT019

3

115338

3

117340

10

1311-8-16

8/5/08/22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	71715
Description: Floor Window		Part Number:	D3212-1
Inspection Dwg: D3212 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
12.734	+/-0.005	12.735	—		Height gage	31006
6.367	+/-0.005	6.367	—		"	"
0.625	+/-0.005	.622	—		Vern	M-7
Ø0.156	+0.005/-0.001	Ø.156	—		"	"
R0.25	+/-0.030	R.250	—		R-L	
8.150	+/-0.005	8.148	—		Height gage	31006
3.750	+/-0.005	3.748	—		"	"
0.313	+/-0.010	.313	—		Vern	M-7
15.14	+/-0.030	15.140	—		M-type	M-2
12.520	+/-0.005	12.520	—		Height gage	31006
6.260	+/-0.005	6.260	—		"	"
1.312	+/-0.005	1.312	—		"	"
0.313	+/-0.010	.313	—		"	"
3.750	+/-0.005	3.750	—		Height gage	31006
8.150	+/-0.005	8.150	—		"	"
8.462	+/-0.005	8.462	—		"	"
9.09	+/-0.030	9.090	—		"	"

Measured by:	<i>[Signature]</i>	Audited by:	<i>[Signature]</i>	Prototype Approval:	N/A
Date:	11/08/18	Date:	11-08-18	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.12.15	New Issue P/O D350-567-015/-025/-031	KJ/RF	
B	07.05.28	Dimensions updated per Dwg Rev. B	KJ/JLM	<i>[Signature]</i>



RELEASED
2011-06-16

8) CHECK DIMENSIONS WITH TEMPLATE D3212-1T1

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 71715

CL 1107107

C	UPDATE TO CURRENT STD; ADD D3212-1B. REASON: PAR11-109.	MB	11.06.03
B	UPDATE MATERIAL PER NCR 029	SSH	08.04.13
A	NEW ISSUE	CP	03.09.03
REV.	DESCRIPTION	BY	DATE
DESIGN	 DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN			
CHECKED			
MFG. APPR.		DRAWING NO.	REV. I
APPROVED		D3212	SHEET 1 OF
DE APPR.	TITLE	SCAL	
DATE	FLOOR WINDOW	NI	
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